

Date: Thursday, 06/11/2008 3:45:50 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 43257		
Estimate Number	: 11162		
P.O. Number	:	Part Number	: D32641
This Issue	: 06/11/2008 S.O. No. :	Drawing Number	: D3264 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 41824	Material	:
Written By	:	Due Date	: 14/11/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JLD 08.11.09</u>		
Comment	: Est A04.09.02 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1250X04500	6061-T6 Bar 1.25 X 4.50
Comment: Qty.: 0.5097 f(s)/Unit Total: 5.0967 f(s) Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B1.250x04.500) Identify for D3264-1 Batch: <u>M109401</u> <u>JLD 08/11/09</u> (10)		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: 4.500" x 1.250" x 5.700" long Bar. <u>JLD 08/11/09</u> (10)		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA447 and Dwg D3264 Identify as D3264-1 Deburr <u>H.A</u> <u>08/11/09</u> PTO		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>H.A</u> <u>08/11/09</u>		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>SS 08/11/11</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3264-1 PAR #: N/A Fault Category: Prod Eng Prog NCR: Yes No DQA: NA Date: 08-11-17
 (D412-706-011/013/015) Resolution: Scrap Disposition: Scrap QA: N/C Closed: NA Date: 08/11/20

NCR: <u>43257</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/10	3.0	Root cause: Programming Error by J.L (1 part)	<u>[Signature]</u> 08/11/10	Correct Prog. - 1 part scrap & destroy Replace Qty 1 M1094101	<u>[Signature]</u> 08/11/10 J.A	<u>[Signature]</u> 08/11/11	<u>[Signature]</u> 08/11/12	<u>[Signature]</u> 08/11/11
		When optimizing Prog, Programmer selected wrong line, Prog now Fixed!						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 43257

Part Number: D32641

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



10X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/11/12

7.0 POWDER COATING

POWDER COATING



M109152



10X

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

3:30 OF

OVEN TEMPERATURE:

320

FINISH TIME:

4:00

M-L 08/11/12

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-13

E10

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock Location: _____

08/11/13

1.1

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



13UF 08-11-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	43257
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.690	✓			
0.063	+/-0.010	0.063	✓			
0.125	+/-0.010	0.125	✓			
0.875	+0.010/-0.020	0.875	✓			
0.062	+/-0.010	0.063	✓			
R0.03	+/-0.030	R0.03	✓			
R0.13	+/-0.030	R0.125	✓			
1.00	+/-0.030	1.010	✓			
0.125	+/-0.010	0.123	✓			
0.600	+/-0.010	0.598	✓			
4.000	+/-0.005	3.999	✓			
0.750	+/-0.010	0.749	✓			
Ø0.194	+0.005/-0.000	Ø0.195	✓			
5.50	+/-0.030	5.500	✓			
0.125	+/-0.010	0.124	✓			
0.063	+/-0.010	0.062	✓			
R0.25	+/-0.030	R0.250	✓			
4.27	+/-0.030	4.273	✓			
R0.30	+/-0.030	R0.30	✓			

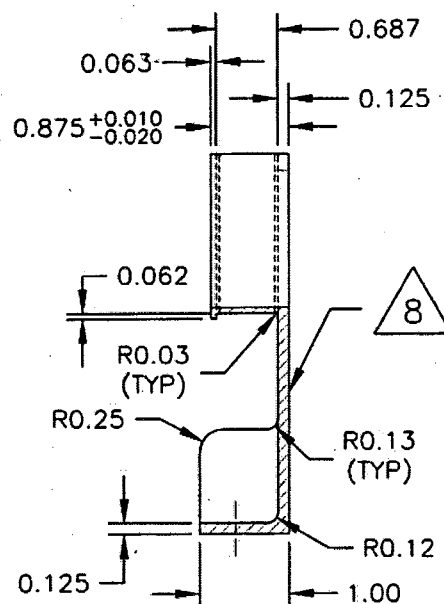
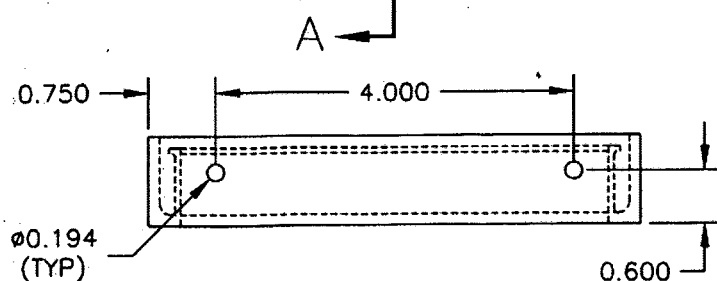
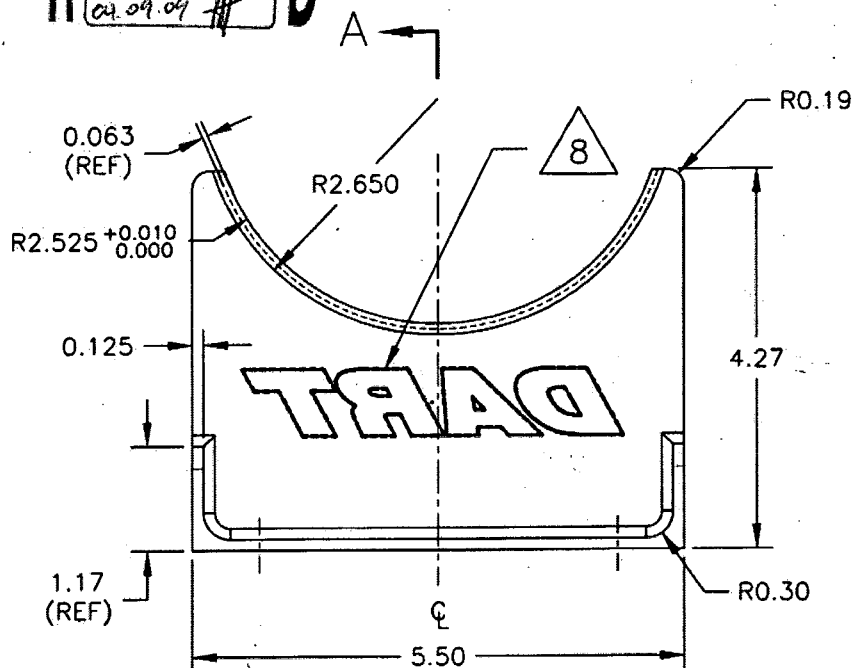
Measured by: H.A	Audited by: SP	Prototype Approval:	N/A
Date: 08/11/09	Date: 08/11/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	

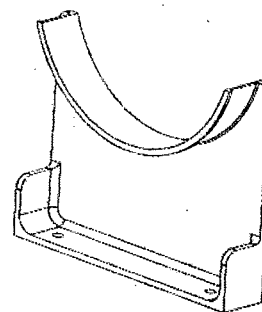


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.09.09 #



SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER NO. 4325
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
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WITHOUT NOTICE
WORK ORDER

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